

Work Order ID 77553

December-13-11 1:41:06 PM

77553

Page 1

Item ID: D3889-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Panel, Floor
 Start Date: 13/12/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 05/01/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/12/13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3889	A								

100 0.00

100

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3889-1

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

B12-1-5

(2)

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC

Quality Control

Memo

0.00

B12-1-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 13/12/2011 **Start Qty:** 2.00

2

Cust Item ID:

Required Date: 05/01/2012 **Req'd Qty:** 2.00

2

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]

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77553

Page 3

Accept

N900040100

Setup Start ***NS1***

Stop *NS2*

Start Date: 13/12/2011 **Start Qty:** 2.00

2

Cust Item ID:

Required Date: 05/01/2012 **Req'd Qty:** 2.00

?

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

0.00

150

Small Fab

Memo

0.00

Small Fab

1- Bond gasket to smooth side of panel as per dwg
A/R 3M 1300 adhesive Batch: 27119597

160

QC5- Inspect part completeness to step on W/O	0.00
---	------

0.00

160

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 0.00

0.00

170

Packaging

Memo

0.00

W/O:		WORK ORDER CHANGES					
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Item ID: D3889-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Panel, Floor

Stop ***NS2***

Start Date: 13/12/2011 Start Qty: 2.00

2

Cust Item ID:

Required Date: 05/01/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

ME
12-01-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 77553

77553

Parent Item: D3889-041

D3889-041

Parent Item Name: Panel, Floor

Start Date: 13/12/2011

Required Date: 05/01/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	2,890.665	8.1925	17.24737			
MI FXS 125-F60029-04									**				
GE PLASTICS LEXAN SHEET													

HB 1-5

				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
				MAT018	2890.665	
				115261	234.665	
				119937	2656	
D3889-3		Manufactured	No		140	Each
						0.0000

D3889-3

Gasket

**

B77553

119937
2
12/01/10
(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

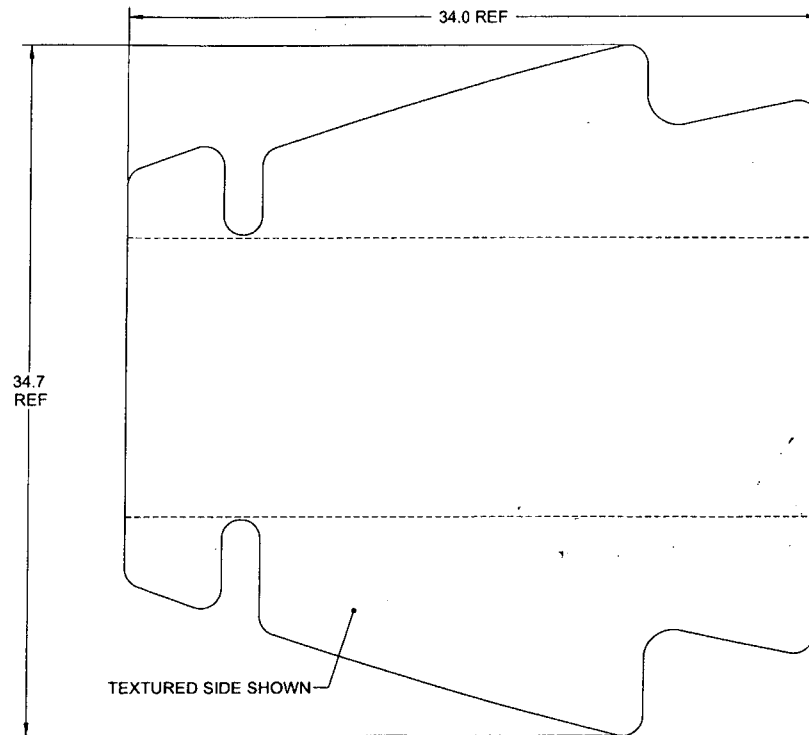
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PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3889-041	PANEL, FLOOR
2	1	D3889-1	PANEL
3	1	D3889-3	GASKET
4	A/R	3M 1300	ADHESIVE

**D3889-041 PANEL, FLOOR**

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3889-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 5.13 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

D3889-1 PANEL

D3889-3 GASKET

8

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 77553 M.L.J

11/12/13

RELEASED
9/26/15 M.P.

A	NEW ISSUE	CP	09.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.04.20		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3889	REV. A
TITLE PANEL, FLOOR	SHEET 1 OF 3
SCALE NTS	

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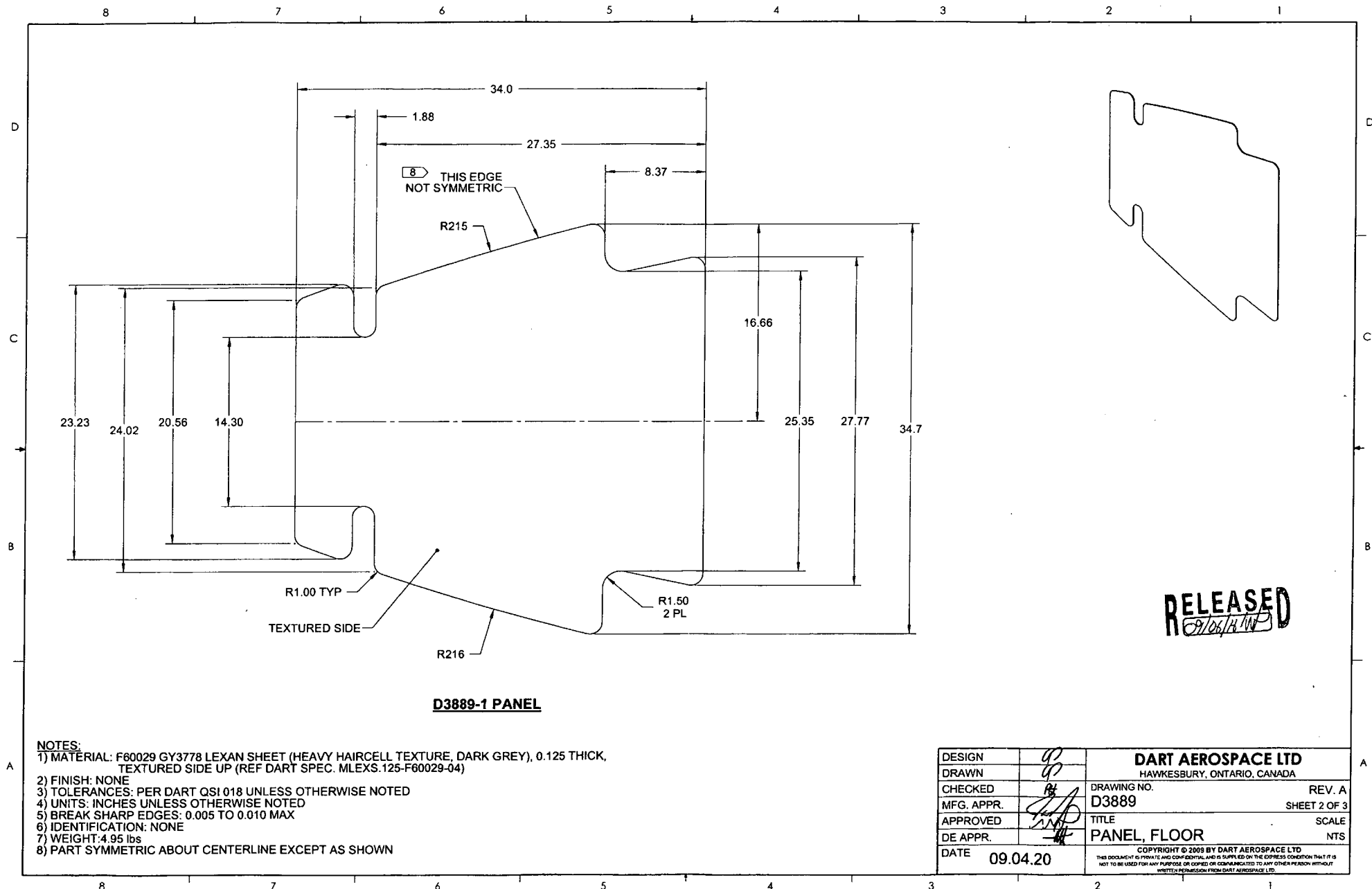
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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77553



RELEASED
09/04/20

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. A
MFG. APPR.	92	D3889	SHEET 2 OF 3
APPROVED	92	TITLE	SCALE
DE APPR.	92	PANEL, FLOOR	NTS
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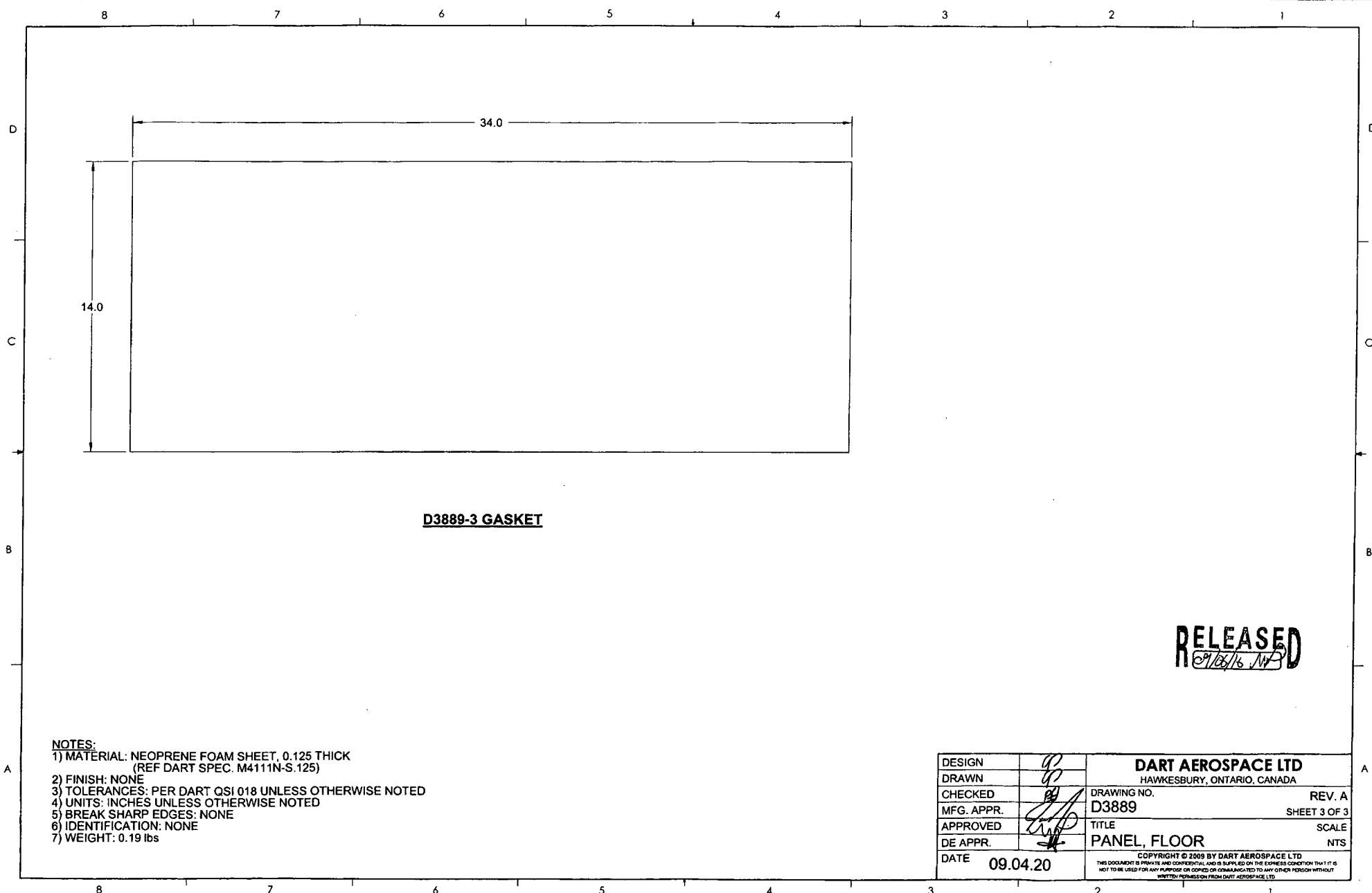
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77553



D3889-3 GASKET

RELEASED
09/06/16 NW

NOTES:

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3889	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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